

Work Order ID 104907 2563

July-23-13 10:59:43 AM

104907

Page 1

Item ID: D2563

104907

REV. C

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Weldment Assembly

Start Date: 7/23/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/06/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *13-07-23* Tooling:

Run Start *NR1*

QC: _____

Date: _____ SPC (Y/N):

Date:

Stop *NR2*

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
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Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2563	Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

4 *0* *13-07-23*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

13-07-24 *DAS 09*

1000
1000

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Item ID: D2563

Accept

N900040100

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Start Date: 7/23/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/06/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

13-07-24

DAS
19
9-89

130

Chemical Conversion Coat per QS1005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

4 13-7-24

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

4 13-07-30

DAS
19
9-89



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4

Required Date: 8/06/13 Req'd Qty: 4.00

4

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Weld per dwg A/R Aluminum rod Batch: 12567 0.00

150

Large Fab

Memo

0.00

Large Fab

1-Inspect for foreign object per QSI 024

2-Weld Remainig End cap as per Dwg D2563 using DT 8343

3-Grind

160

QC10- Inspect visual per QSI004- ground welds 0.00

160

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O 0.00

170

QC

Memo

0.00

Quality Control

4 13-07-30

13-07-30

13-07-30

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Page 4

Item ID: D2563

Accept

N900040100

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Revision ID:

Stop *NS2*

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Cust Item ID:

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4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

175

Pressure Wash per QSI005 4.3

0.00

175

HandFinish

Memo

0.00

Hand Finishing

Touch up Alodine as per QSI005

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

180

Powdercoat

Memo

0.00

Powder Coating

Touch up Alodine then
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:15
320°F
9:45
1112601

190

Wing Walk as per dwg QSI005 4.4 Batch

0.00

190

HandFinish

Memo

0.00

Hand Finishing

4x Ø m-f 13/07/31

4x Ø m-f 13/07/31

4x Ø m-f 13/07/31

m126125

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Item ID: D2563

Accept

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

DAS 16 13/07/06

4

Quality Control

Tay + Stamp

210

Identify as per dwg & Stock Location:

0.00

210

Packaging

Memo

0.00

PPP 104492

4 8 13-8-6

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

MJS 13-08-06

Quality Control

MJS 13-08-06

Picklist Print

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Work Order ID: 104907

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Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 7/23/13

Required Date: 8/06/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116		Manufactured	No			100	Each	42.2105	1	4			
D2244-116									**			11.07.23	
STEP EXTRUSION													

Location

Loc Qty

Loc Code

WA

-0.0000368

WA003

42.2104894

60307

2

80803

17.2104894

89954

23

D2561

Manufactured No

100

Each

26.0000

2

8

D2561

**

Lug

Location

Loc Qty

Loc Code

WA003

26

66813

5

99027

21

D2564

Manufactured No

100

Each

49.0000

2

8

D2564

**

Mounting Angle

Location

Loc Qty

Loc Code

WA

9

99050

9

WA003

40

99527

40

Picklist Print

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Work Order ID: 104907

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

104907

D2563

Start Date: 7/23/13

Required Date: 8/06/13

Start Qty: 4.00

Required Qty: 4.00

D2673-34

Manufactured No

100

Each

93.0000

4

D2673-34

End Plate

**

113.07.23

Location

Loc Qty

Loc Code

WA003

93

103377

85

97990

8

4

D2673-34

Manufactured No

150

Each

93.0000

4

D2673-34

End Plate

**

113.07.30

Location

Loc Qty

Loc Code

WA003

93

103377

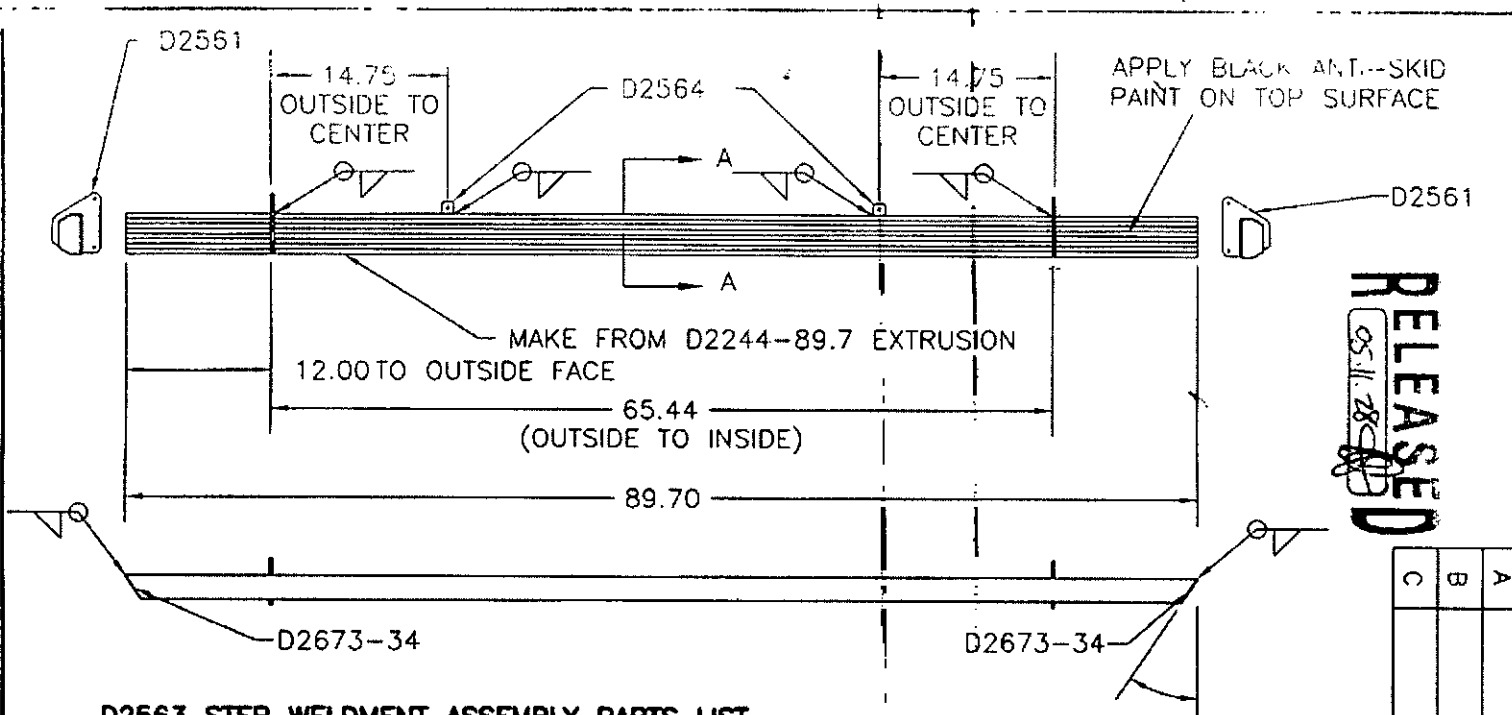
85

97990

8

4

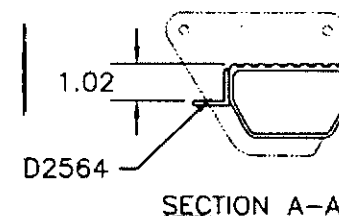
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D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.28

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	BT	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
BT	BT	D2563
DATE	TITLE	REV. C
05.11.14	STEP WELDMENT ASSEMBLY	1:15
A	96.04.26	NEW ISSUE
B	97.05.14	END CAPS CHANGED (WAS D2248)
C	05.11.14	UPDATE NOTES

DART

04907
MLJ
1307-23

